

# Work Order ID 54641

December 15, 2009 11:31:28 AM



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Item ID: D3492-053

Accept



Setup Start



Revision ID:

Item Name: Plug Assembly

Stop



Start Date: 12/15/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 12/18/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan: MF

Date: 09-12-15 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3492

Rev C

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-Turn as per Folio FA715 & Dwg D3492 □ Dwg Rev: C □ Folio  
Rev: N/A

SA 09/12/21

67 φ

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

SA 09/12/21

67 φ

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00


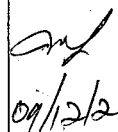
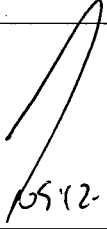

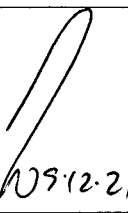

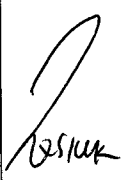
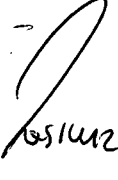
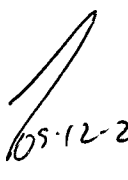
Quality Control

N.A 09/12/21

67 φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3492-053 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: 1 Date: 05.12.22  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>54641</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05.12.21	100	1 plug scrap. Part has a inside taper on the face of it. Appears to be the 1st part run i. this is from the end of the material from the previous job.		Scrap: no replace	 09/12/21	 05.12.21	 05.12.21	 05.12.21
		R.C. <del>material</del> material.  ex.					 05.12.21	 05.12.21

NOTE: Date & initial all entries



# Work Order ID 54641

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Item ID:	D3492-053	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Plug Assembly					
Start Date:	12/15/2009	Start Qty: 40.00		Cust Item ID:		
Required Date:	12/18/2009	Req'd Qty: 40.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M 113170</i> Memo (Flat End Only) <input type="checkbox"/> START TIME: <i>10:30</i> <input type="checkbox"/> OVEN TEMPERATURE: <i>320°</i> <input type="checkbox"/> FINISH TIME: <i>11:00</i>	0.00 0.00				<i>Bl 09-12-22</i> <i>(66)</i>			
170  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00				<i>M 09-12-22</i> <i>(x66)</i>			<i>Ø</i>
180  Packaging Packaging	Identify as per dwg & Stock Location: <i>FP-B</i>  Memo	0.00 0.00				<i>Bl 09-12-22</i> <i>(66)</i> , <i>Ø</i>			

# Picklist Print

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Work Order ID: 54641



Parent Item: D3492-053



Parent Item Name: Plug Assembly

Start Date: 12/15/2009

Required Date: 12/18/2009

Comments:

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6R0.750		Purchased	No			100	f	93.5864	1.9284			
6061-T6 Round Bar .750"												

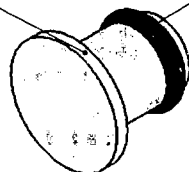
<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	93.5864	
110791	2.97	
112041	2.3164	
112442	50	
112663	38.3	

3.8 PL 8/12/21



D3492-XX PLUG  
(SEE TABLE)

NAS1611 PLUG  
(SEE TABLE)



### D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
X							D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
			X				D3492-047	PLUG ASSEMBLY
				X			D3492-049	PLUG ASSEMBLY
					X		D3492-051	PLUG ASSEMBLY
						X	D3492-053	PLUG ASSEMBLY
1							D3492-1	PLUG
	1						D3492-3	PLUG
		1					D3492-5	PLUG
			1				D3492-7	PLUG
				1			D3492-9	PLUG
					1		D3492-11	PLUG
						1	D3492-13	PLUG
		1					NAS1611-005	O-RING
			1				NAS1611-007	O-RING
1							NAS1611-010	O-RING
						1	NAS1611-012	O-RING
	1						NAS1611-013	O-RING
					1		NAS1611-015	O-RING
				1			NAS1611-016	O-RING

△ △ △

#### NOTES:

1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

#54691

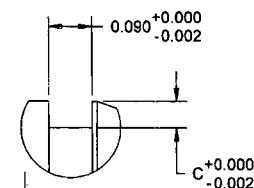
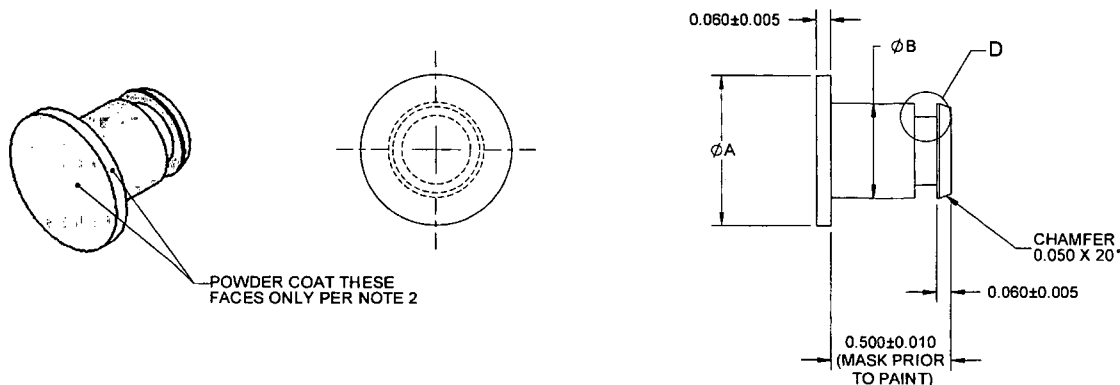
~~UNDER REVIEW~~  
08.04.08  
OK ASS 08.11.12

DEO ATTACHED

RELEASED  
01.11.16

C	ADD -049/-051/-053. CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047; UPDATE DIM A FOR -045	PH	06.05.11
A	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.10.05		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. C SHEET 1 OF 2 SCALE 2:1	
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8 7 6 5 4 3 2 1



**DETAIL D**

# 54641

**D3492-XX PLUG**

**D3492-XX PLUG MACHINING DETAILS**

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.055	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500
D3492-9	0.938	0.750	0.045	M6061T6R1.000
D3492-11	0.850	0.664	0.045	M6061T6R0.875
D3492-13	0.750	0.520	0.045	M6061T6R0.750

**NOTES:**

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

UNDER REVIEW

01.04.11 RB

DEM. 16 ON D3492-13  
REF. 02 (WHITE SMALLER)

15508.11.12

OKay

DEO ATTACHED

RELEASED  
07.11.16

DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO.
MFG. APPR.		<b>D3492</b>
APPROVED		TITLE
DE APPR.		<b>PLUG</b>
DATE	<b>07.10.05</b>	SCALE
		<b>4:1</b>

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8 7 6 5 4 3 2 1



DRAWING NO. D3492	TITLE PLUG	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3492-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED	MFG. APPR.	APPROVED		DE APPR.		
DATE 08.11.05	DATE 08.11.05	DATE 08.11.05	DATE 08/11/05		DATE 08/11/05		

SHEET 2 MODIFY -13 PLUG AS SHOWN:

IS:

**D3492-XX PLUG MACHINING DETAILS**

P/N	A	B	C	MATERIAL SPEC
D3492-13	0.750	0.510	0.045	M6061T6R0.750

# 54641

WAS:

**D3492-XX PLUG MACHINING DETAILS**

P/N	A	B	C	MATERIAL SPEC
D3492-13	0.750	0.520	0.045	M6061T6R0.750

**RELEASED**  
08/11/10